

Work Order ID 71652

Thursday, July 07, 2011 12:04:34 PM



Page 1

Item ID: D3205-1

Accept



Setup Start



Revision ID:

Item Name: Pedal Bracket

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/07/07 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3205	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

Re 11.9.21 6

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1

☐

Deburr and Tumble

FK

Re 11.9.21 6

PTO

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00


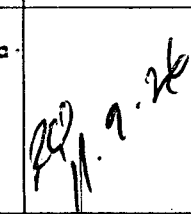
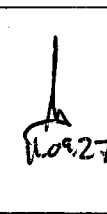

Quality Control

FK

Re 11.9.21 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3205-1 PAR #: 24 Fault Category: Machining NCR: Yes No DQA: 1A Date: 11-10-14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/10/14

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/9	110	2.380" and .250" under tolerance by .002" and .004" 3rd operation holding full between the two surfaces of the vice causing the workpiece to lift into the cutter on one side. R.L. Process	 11.09.27 Q51042	• Scrap + replace • B/N: M116680 Qty +1	F.K. 11/09/26	 11.9.26	 11.09.27	 11.09.27

NOTE: Date & initial all entries

Work Order ID 71652

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Page 2

Item ID: D3205-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Bracket

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check 0.00

0.00

and 11/09/27

6 8



QC Memo 0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1 0.00

0.00



HandFinish Memo 0.00

Hand Finishing

6X Ø M-L 11/09/28

150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

0.00



Powdercoat Memo 0.00

Powder Coating

6X Ø M-L 11/09/28

Note: Cover the thread hole for D3205-1 before powder coat. ☐ START TIME: *3:45* ☐ OVEN TEMPERATURE:

3204-3:45 FINISH TIME:

3:45

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71652

Thursday, July 07, 2011 12:04:35 PM

Page 3

Item ID: D3205-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Pedal Bracket

Start Date: 7/7/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6 6000	d	11	11/09/20
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>C.A</u> Memo	0.00 0.00							EB 11/09/29
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/10/30 MF 11-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:04:32 PM

Page 1

Work Order ID: 71652



Parent Item: D3205-1



Parent Item Name: Pedal Bracket

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A□04.06.09□New issue□KJ/RF□
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased		No		100	f	8.1900	0.3646	2.302737			



7075-T73 Bar 2.50 x 3.25



2 11.9.21

Location

Loc Qty

Loc Code

MAT008

8.19

116680

8.19

2.125'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71652
Description: Pedal Bracket		Part Number:	D3205-1
Inspection Dwg: D3205 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.096				
0.250	+/-0.010	.255				
R0.37	+/-0.030	.37				
0.125	+/-0.010	.135				
0.250	+/-0.010	.243				
2.380	+/-0.010	2.376				
1.380	+/-0.005	1.379				
0.500	+/-0.005	.502				
0.880	+/-0.010	.880				
Ø0.470 x 100°	+0.005/-0.000	.470 x 100°				
0.440	+/-0.005	.441				
0.600	+/-0.005	.598				
1/4-28UNF-313	N/A	1/4-28 UNF-313				
0.250	+/-0.010	.255				
Ø0.257	+0.005/-0.000	.257				
1.750	+/-0.010	1.750				
0.870	+/-0.005	.869				
0.440	+/-0.005	.441				
R0.25	+/-0.030	.25				

Measured by: F.K. / J	Audited by: and	Prototype Approval:	N/A
Date: 11/09/22	Date: 11/09/27	Date:	N/A

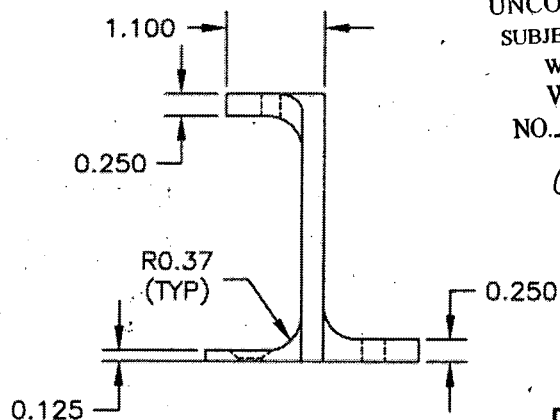
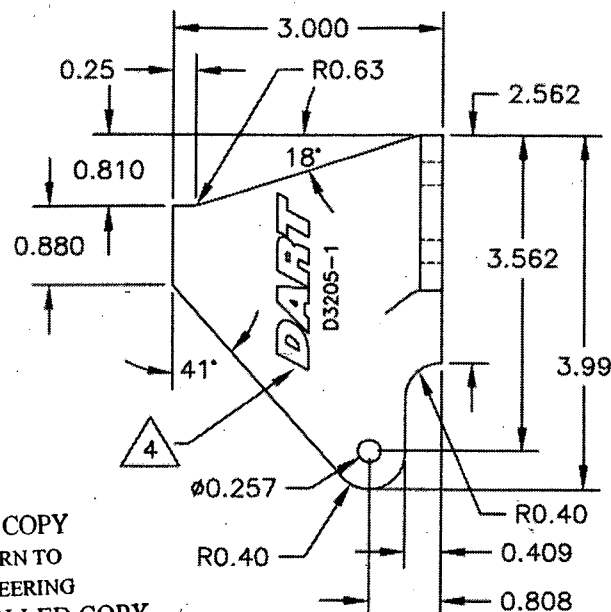
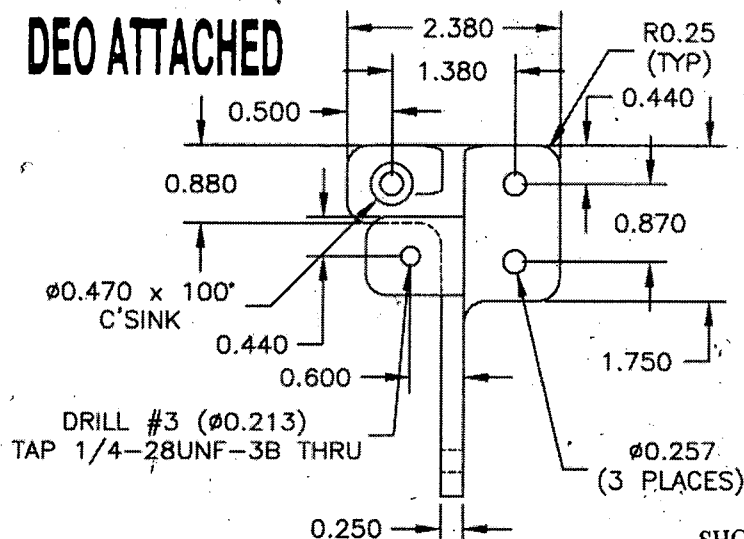
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

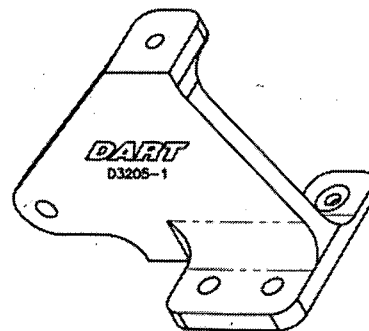
RELEASED
04.04.05

DEO ATTACHED



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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71652

CZ1107/07



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

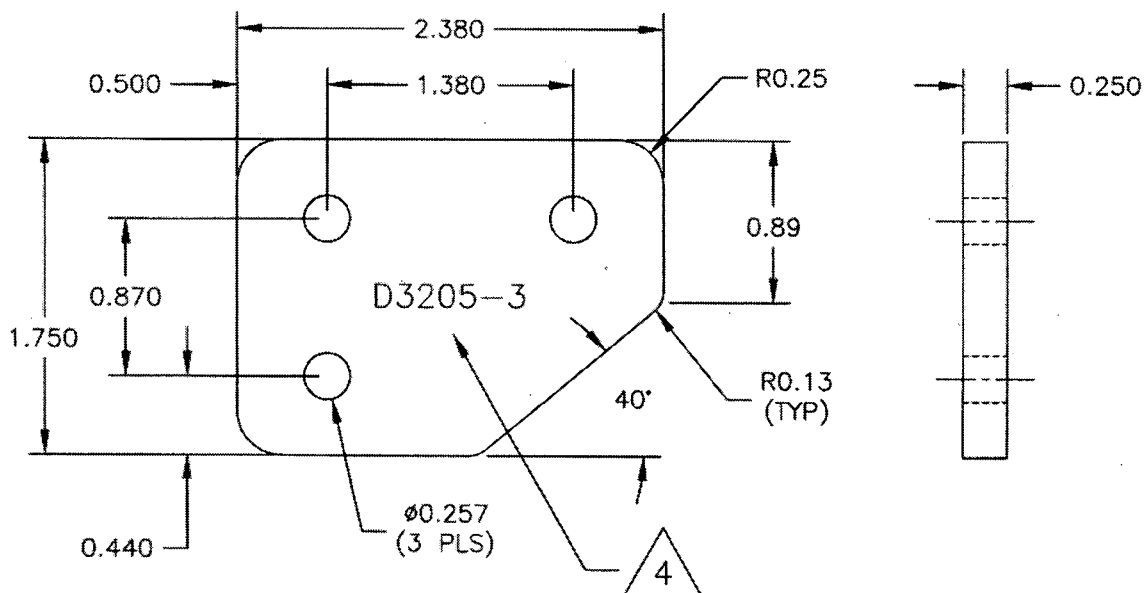
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
04.01.27	04.01.27	D3205	REV. A	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 2	
DATE		TITLE	SCALE	
		BRACKET	1:1	

RELEASED
04.01.27
DEO ATTACHED



D3205-3 BACK PLATE

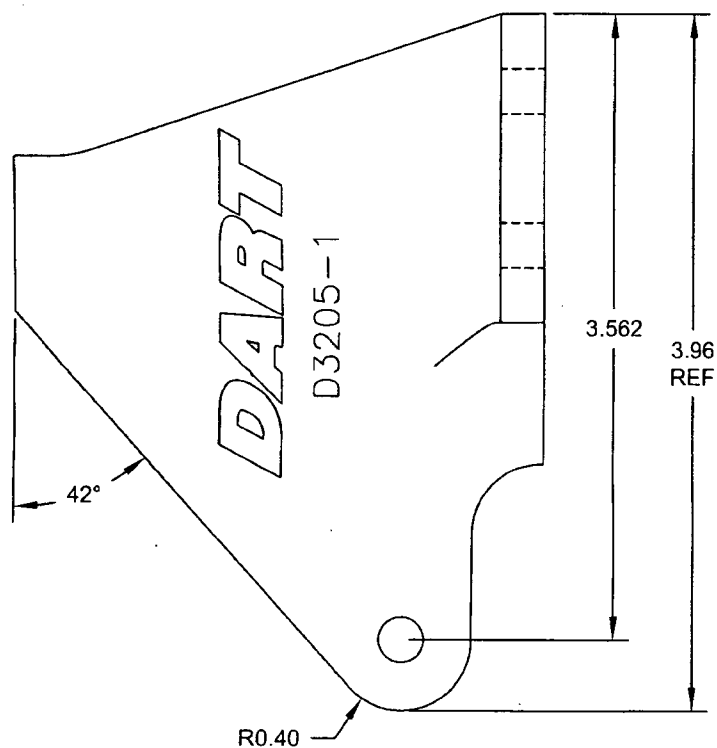
NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

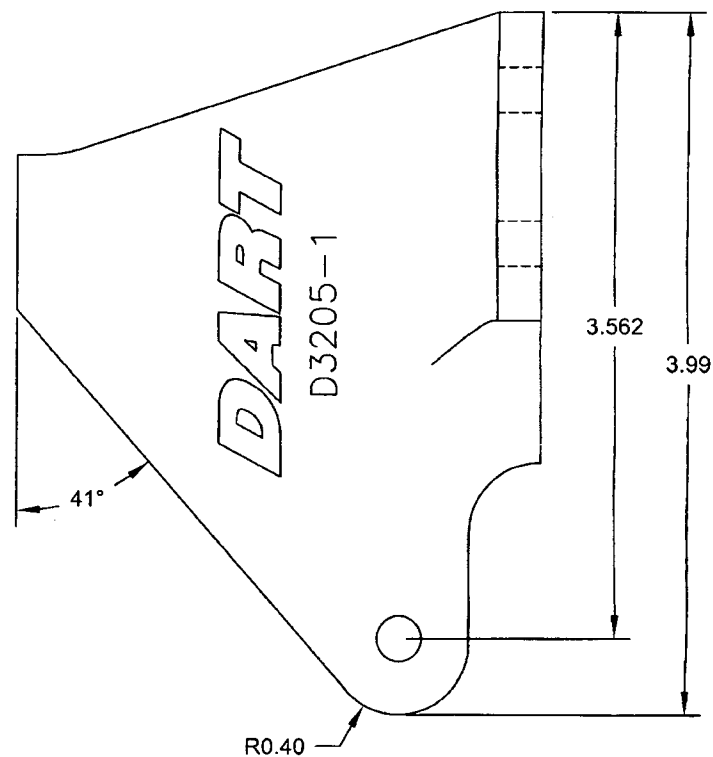
DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01	DATE 08.12.01		

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:



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